

Date: Wednesday, 23/08/2006 11:42:21 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET				
Job Number	: 28254B							
Estimate Number	: 10339							
P.O. Number	: N/A			Part Number	: D2658			
This Issue	: 23/08/2006	S.O. No. : <i>N/A</i>	Drawing Number	: D2658 REV D				
Prsh't Rev.	: NC			Project Number	: N/A			
First Issue	: 21/08/2006	Type : PURCHASED PARTS	Drawing Revision	: D				
Previous Run	: 27219		Material	: N/A				
Written By				Due Date	: 12/09/2006			
Checked & Approved By				Qty:	30			
Comment	: Est Rev:A New Issue 05-11-07 JLM			Um:	Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S12GA	1010/1025/A21/6aA SHEET 
		Comment: Qty.: 0.1140 sf(s)/Unit Total : 3.4200 sf(s) 1010/1025/A21/6aA SHEET <i>Batch # M101094</i>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET <i>SAD 06:08:26</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD 06:08:26</i>
4.0	QC8	SECOND CHECK 
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2658T1 <i>06:08:29</i>
5.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE 1-Deburr as required. <i>SAD 06:08:30</i> <i>30</i> 2-Bend on CNC brake using DT8254Identify as D2658 <i>SB 06/09/13</i> <i>30</i>

Date: Wednesday, 23/08/2006 11:42:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28254B

Part Number: D2658

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>Job 08-14 (30)</i>
7.0	DC	DOCUMENT CONTROL
		<i>Doc 09/19 (30)</i>
Comment: INSPECT WORK TO CURRENT STEP		
Comment: DOCUMENT CONTROL		
Inspection Level 21		

Job Completion



6.1 Identify and Stock.
Location WS
24 30

PTO

11/06/09/18

u 06-09-19

Date: Monday, 8/21/2006 2:11:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET		
Job Number	: 28254B					
Estimate Number	: 10339					
P.O. Number	:			Part Number	: D2658	
This Issue	: 8/21/2006		S.O. No. :	Drawing Number	: D2658 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 27219			Material	:	
Written By	:			Due Date	: 9/12/2006	
Checked & Approved By	: <u>OK 06.08.21</u>			Qty:	30	Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: _____ Laser cut per Drawing Flat pattern D2658 Material release note required	<i>114 SF waterjet</i>
2.0	D2658F	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) Lug Bracket	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2658T1	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Deburr as required. 2-Bend on CNC brake using DT8254Identify as D2658	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-09-14	6.1	Add I.D. to stock. Perm. Change			R	06-09-28			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 1Date: 06/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 8/21/2006 2:11:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28254B

Part Number: D2658

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

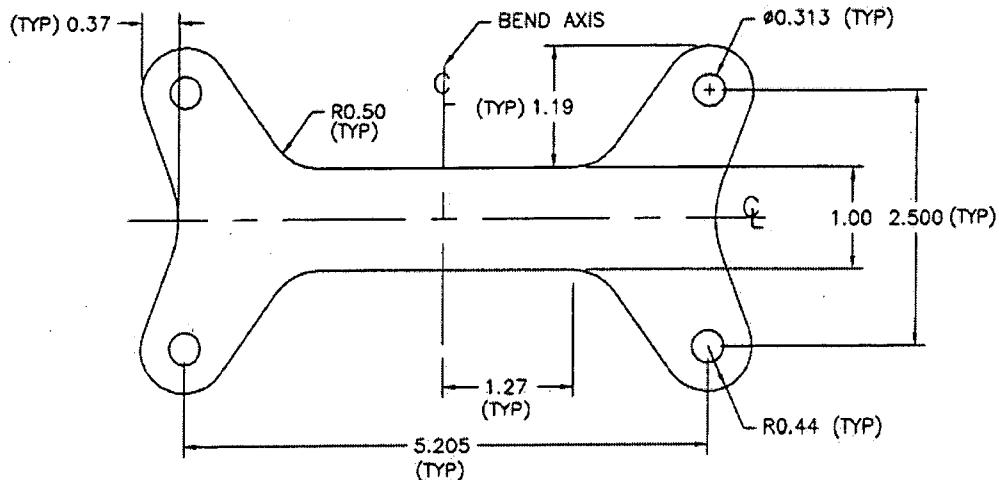
QA: N/C Closed: _____ Date: _____



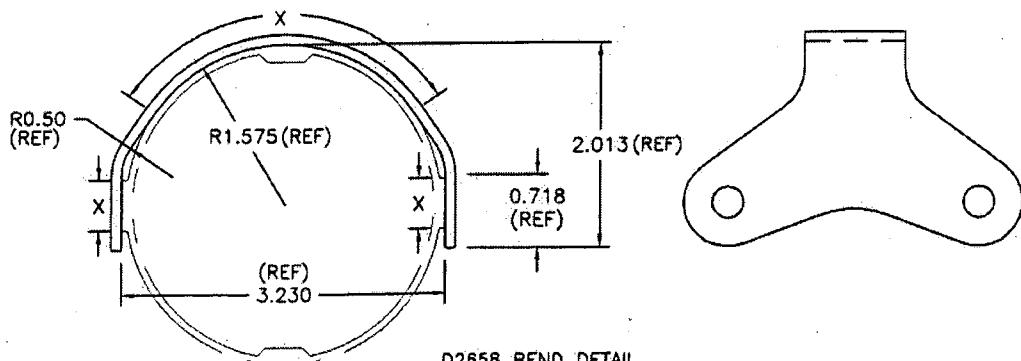
COPIES
MADE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14	TITLE LUG BRACKET		SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28254B*

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:	28254B
Description:	Part Number:	D2658
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	JAD
Date:	06/01/26

Audited by: ✓
Date: 06-06-29

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

